									÷	
	er ID 71849 13, 2011 10:22:02 AM									Page 1
Revision ID:	D3457-1 Washer		Accept					Setup Sta	[
Start Date: Required Date: Reference:	7/14/2011 Start Qty: 60.00 7/28/2011 Req'd Qty: 60.00			Cust Item :						
Approvals:	Process Plan: MC QC:	Date: //-07-/3 Tooling: Date: SPC (Y/N		Date:			Run Sta			
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr				T. Allendard Michigan					
100 Doosan Doosan Lathe	DOOSAN LATHE	olio FA589 Rev: AA&	0.00 0.00 Dwg D3457 Rev: A	P4 11.	7.19	y.	Ø			

QC2- Inspect parts off machine FAI/FAIB

0.00

R9 11.7.19 60

Quality Control

Memo

0.00

120

QC8- Inspect parts - second check

0.00

Memo

0.00

W17/14

Quality Control

W/O:			W	ORK ORDER CHANG	ES	W. W. J. P. B							
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A:	Date: _					
		esolution:											
NCR:			WORK ORDER NON-CONFORMANCE (NCR)										
DATE	STEP	Description of NC	Description of NC Corrective Act		Section B Verif			Approval	Approval				
	OIL!	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	Secti	on C	Chief Eng	QC Inspector				
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Work Order ID 71849

Wednesday, July 13, 2011 10:22:02 AM



Page 2

Item ID:

D3457-1

Accept



Setup Start

Stop



Revision ID:

Item Name: **Start Date:**

Washer

7/14/2011

Start Qty: 60.00 Req'd Qty: 60.00

Cust Item ID:

Customer:

Reference:

Process Plan: _____ Date: ____

Tooling:

Date:

Start Run

Approvals:

Required Date: 7/28/2011

Date: _____

SPC (Y/N):

Date:

Stop

Sequence ID/ **Work Center ID**

130

Packaging

Packaging

Operation Description

QC: _____

Identify as per dwg & Stock Location:____

Memo

Set Up/ **Run Hours**

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

140

QC21- Final Inspection - Work Order Release

0.00



Quality Control

QC

Memo

0.00

MF 1-07-15

W/O:			WO	RK ORDER CHANGI	ES				
DATE	STEP	PRO	CEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
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Part No:	:	PAR #:	Fault Cate	jory:	NCR: Yes	No DQA	:	_ Date: _	
		esolution:							
NCR:	WORK ORDER NON-COI				NCE (NCR)			
DATE	STEP	Description of NC	ļ		veri			Approval	Approval
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	n C	Chief Eng	QC Inspector
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Picklist Print

Wednesday, July 13, 2011 10:22:00 AM

Work Order ID: 71849

Parent Item:

D3457-1

Parent Item Name: Washer



Start Date: 7/14/2011

Required Date: 7/28/2011

Page 1

Start Qty: 60.00

Required Qty: 60.00

Comments:

IPP A□05.10.03□New issue□KJ/JLM□

IPP Rev:B Now on Doosan Lathe 08-10-30 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINRI.000	I Bung fo r ri en subisk borg og sig i	Purchased	No			100	f	32.4070	0.0208	1.313684			
										130	11.	7.1	4
Delrin Round Bar 1"													<u> </u>

Location	Loc Qty	Loc Code	
MAT055	32.407		
117985	0.407		
118257	· 32		2

MDELRINR1.000 M118257

		——————————————————————————————————————							
W/O:			W	ORK ORDER CHANGE	S		· ·-		
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _	
			Dispositio	n:	QA: N/C Cl	osed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR	3)			
DATE	STEP	Description of NC	Corrective Action Section		Verific	ation	Approval	Approval	
DAIL	O.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti		Chief Eng	QC Inspector

DART AEROSPACE LTD	Work Order: 7/849	
Description: Washer	Part Number: D3457	'-1
Inspection Dwg: D3457 Rev: A	Page 1	of 1

mopositon Birg.		*					ge i oi i
	FIRS	ST ARTICLE IN	SPEC <u>TI</u>	ON CHE	ECKLIST		
		X First Artic	cle	Prot	otype		
Drawing	T .1.	Actual	_		Method of		
Dimension	Tolerance	Dimension	Accept	Reject	Inspection		nments
R1.575	+/-0.010	21.575			Rep. 02		
0.030 x 0.030	+/-0.010	035 K. 639					
0.530	+/-0.010	,528					
0.063	+/-0.010	.065					
0.169	+/-0.010	,167					
Ø0.655	+/-0.010	.654					
Ø1.000	+/-0.010	1-004			(1		

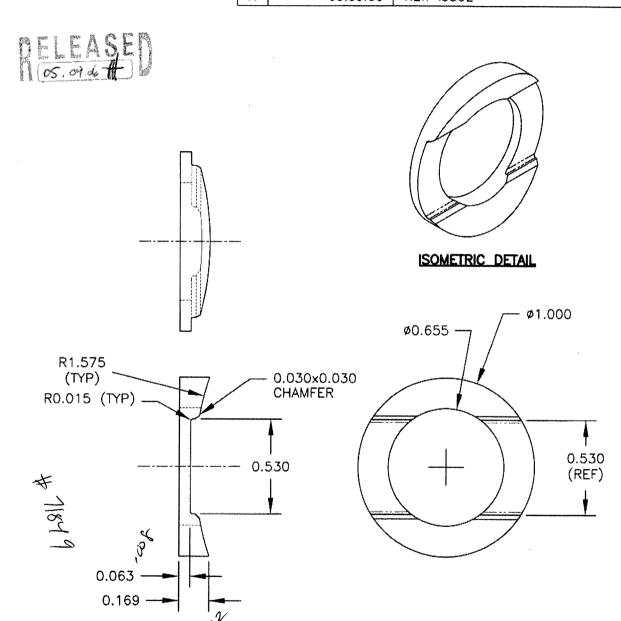
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Date: (7.14	Date:	11/1/	14		Date:	N/A
Rev Date	Change			7	R	Revised by	Annrove
	New Issue			-		J/EC	Approve

		r <u> </u>		
Rev	Date	Change	 Revised by	Approved
Α	08.11.28	New Issue		Apiorea

Dart Ae	rospace	e Ltd							Fo 4 .
W/O:			W	ORK ORDER CHANGE	S				
DATE	STEP	PRO	CEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									
Part No	:	PAR #:	_ Fault Cate	egory:	NCR: Yes	No DQ	A:	_ Date: _	<u>. </u>
	R	esolution:	_ Disposition	on:	QA: N/C Cld	sed:		Date: _	· · · · · · · · · · · · · · · · · · ·
NCR:		W	ORK ORD	DER NON-CONFORMA	NCE (NCR)			
DATE	OTED	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Chief Eng	QC inspector
									·



DESIGN	CP	DRAWN BY	DART	AEROSPACE USA, INC.
CHECK	ED M	APPROVED	DRAWING NO.	REV. A
	卅	-#	D3457	SHEET 1 OF 1
DATE			TITLE	SCALE
05.0	9.06		WASHER	2:1
Α		05.09.06	NEW ISSU	JE



D3457-1 WASHER

- 1) MATERIAL: DELRIN (DART SPEC. M-DELRIN-R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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W/O:		,	W	ORK ORDER CHANG	iES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
•				1.7					-
Part No		PAR #:							
Resolution:		solution:						Date: _	
NCR:		•	WORK ORD	ER NON-CONFORM	ANCE (NCF	R)			
DATE	STEP	Description of NC	Description of NC Corrective Action			Verific	cation	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		on C	Chief Eng	QC Inspector
		-							